



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB877528-4-17
Job Sheet 170020



Part No: RB877528-4-17

Job Qty: 4 ea

Part Name: R & I Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/8/18

Job Tracking No:

Due Date: 1/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP REV:A 17.10.31 NEW ISSUE JFC VERF:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/25/17	0.00	0.00	Start Up Machining-1		SL 18-19
110	CNC Lathe	4 pcs		12/26/17	0.00	2.67	MORI SL-154		jk
120	QC	4 pcs		12/26/17	0.00	0.00	QC2 Machining-4		jk
130	QC	4 pcs		12/26/17	0.00	0.00	QC8 Machining-4		B = 18-01-11
140	QC	4 pcs		12/26/17	0.00	0.00	QC5		
150	Outsource	4 pcs		1/10/18			GRO002-VC Outsource 12		At 18/02/01
160	Packaging	4 pcs		1/10/18	0.00	0.00	Packaging2		A TUR 02/01
170	QC	4 pcs		1/10/18	0.00	0.00	QC5		38
180	Packaging	4 pcs		1/10/18	0.00	0.00	Packaging3-1 GA		9-89 DAS
190	QC21-SA	4 Ea		1/10/18	0.00	0.00	QC21		6

Part Op 110 - 1-Machine as per folio:FB613 FOLIO REV: 025A DWG REV: 3 2-DEBURR

Descriptions: 150 - -Issue P/O to Groupe Altech; PO 13 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

JAN 17 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MT-1144-R1.000	0	20	0	0

5000809

.49

Part Specifications

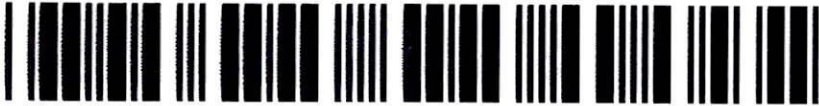
Specifications could not be found.

Plex 1/8/18 9:20 AM Dart.lajeunesse.marie

DART
AEROSPACE
S030362

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



R & I Adapter

PART NO: RB877528-4-17

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 01/09/18

Job No: 170020

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

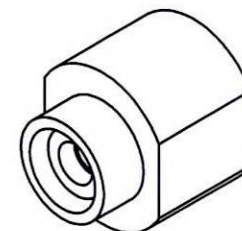
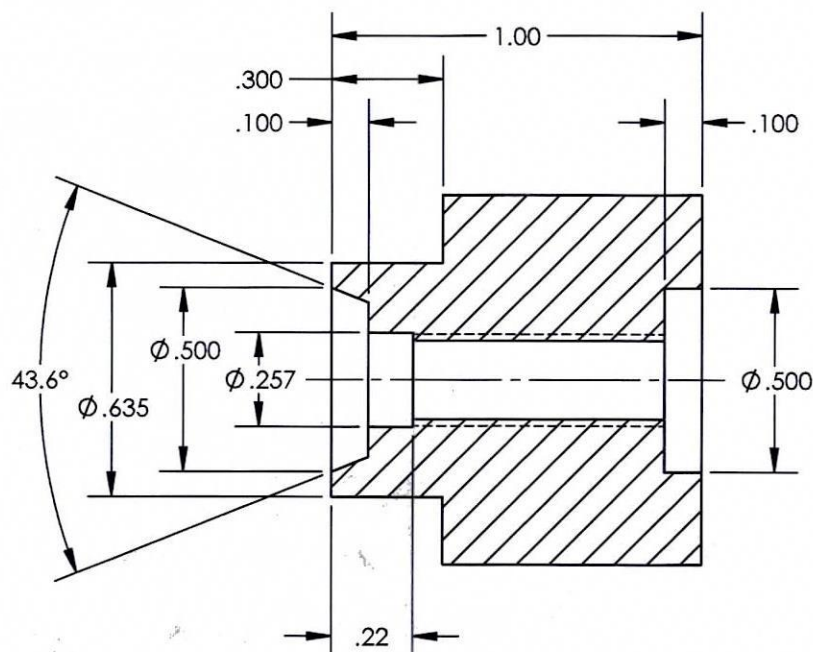
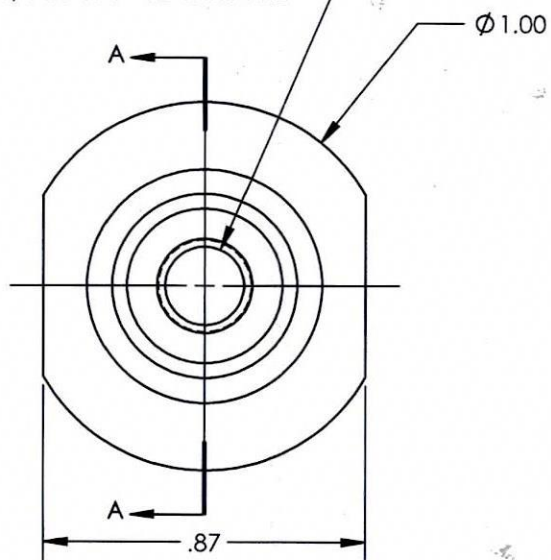
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
3	15-0104	-17 DELETED DIMS .493, .420. ADDED DIM 43.6°. CORRECTED TYPO ON THREAD CALLOUT.			5/14/2015	DPD	JAG

1/4-28 UNF - 2B THRU ALL



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170020

MCS
18-01-08

SECTION A-A

(-17)

R & I ADAPTER

DART AEROSPACE	
TITLE DAMPER BEARING TOOL KIT	
DWG NO. RB877528-4-17	REV 3
MAT'L STRESSPROOF	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. West</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± .5°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	MD 500D
SCALE 2:1	DATE 6/28/2000
SHEET 7 OF 9	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038806**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO038806

PO Date: 1/17/18

Due Date: 1/31/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane Phone:
dbaker@dartaero.com

*Revised \$
P/O*

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	169661	RBW6405G08832-3G-01	Install Rod -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	1/26/18	4 pcs	0 pcs	4 pcs	\$22.50/pcs	\$90.00
						✓ 4x				AT 18/01/29
2	169786	SK145-0115-20	Clamp Bar ISSUE P/O: _____ PASSIVATE AS PER DWG ACCORDANCE WITH ASTM A967 C OF C IS REQUIRED	Firmed	1/26/18	5 pcs	0 pcs	5 pcs	\$20.00/pcs	\$100.00
						✓ 5x				AT 18/02/09
3	170020	RB877528-4-17	R & I Adapter -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	1/26/18	5 pcs	0 pcs	5 pcs	\$10.91/pcs	\$54.55
						✓ 5x				AT 18/02/09
4	170017	RB877528-4-1	Shaft -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	1/26/18	5 pcs	0 pcs	5 pcs	\$10.91/pcs	\$54.55
						✓ 5x				AT 18/02/09
5	169098	RB6795635-2	Socket Assembly -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	1/26/18	1 pcs	0 pcs	1 pcs	\$10.91/pcs	\$10.91
						✓ 1x				AT 18/02/09



Certificat de Conformité / Certificate of Compliance

(005929-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

005929 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
25-Jan-2018		Curtis Anderson				038806			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBW6405G08832-3G-01 Rev.	INSTALL ROD 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] SPÉC: ASTM B633 TYPE 1 SC2 ***	ZINC CH	4	4	0	0	0	
2	SK145-0115-20 Rev.	SK145-0115-20 01 -PASSIVATION- #3 [PASSIVATION #3] SPÉC: ASTM A967 C OF C *** SPÉC: AS PER DRAWING ***	PASSIVATION CH	5	5	0	0	0	
3	RB877528-4-17 Rev.	R & I ADAPTER 01 -OXIDE BLACK [OXIDE BLACK] SPÉC: MIL-C-13924C CLASS 1 ***	OXIDE-BLACK CH	5	5	0	0	0	
4	RB877528-4-1 Rev.	SHAFT 01 -OXIDE BLACK [OXIDE BLACK] SPÉC: MIL-C-13924C CLASS 1 ***	OXIDE-BLACK CH	5	5	0	0	0	
5	RB6795635-1 Rev.	RB6795635-1 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C: CLASS 1 ***	BLACK-OXIDE CH	1	1	0	0	0	
6	646.3912 Rev.	646.3912 CAD PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM CH	30	30	0	0	0	
7	646.3913 Rev.	646.3913 CAD PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM CH	5	5	0	0	0	
8	646.3911 Rev.	646.3911 CAD PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM CH	9	9	0	0	0	
9	646.3910 SHIM Rev.	646.3910 SHIM CAD PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM CH	27	27	0	0	0	

YUL

Page 1 of

yul



Certificat de Conformité / Certificate of Compliance

(005929-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

005929 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.						
25-Jan-2018	Curtis Anderson		038806						
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details	Description pièce(s)	CATG. U/M	Quantités / Quantities	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
	Job # / Ref #								

Notes Additionnelles / Additional Notes

Épaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.